

Work Order ID 127429

127429

Page 1

December-17-14 1:23:53 PM

Item ID: D407-802-015

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: High Vis Crew Door Opener Retrofit LH or RH

Stop

NS2

Start Date: 12/09/14 Start Qty: 1.00

1

Cust Item ID:

Required Date: 12/17/14 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MCS Date: 14-12-22

Tooling:

Date:

QC: Date:

SPC (Y/N):

Date:

Run Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D407-802-1	A							MCS 1504-16	
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile and create labels per PPP D407-802-015 CHG002								
105	Pick Kit	0.00							
105									
Packaging	Memo	0.00							
Packaging									
110	QC4- 100% Inspect kits for completeness	0.00							
110									
QC	Memo	0.00							
Quality Control									

(1x)

DAS
46
9-89

APR 22 2015

IX

DAS
26
9-89

APR 15 2015

(1x)

DAS
46
9-89

APR 16 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 127429

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127429

Page 2

Item ID: D407-802-015

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: High Vis Crew Door Opener Retrofit LH or RH

Stop ***NS2***

Start Date: 12/09/14 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 12/17/14 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	Packaging	0.00							
120									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPPD407-802-015								
	Location: <u>021</u>								
	PPP rev: _____								
130	QC21- Final Inspection - Work Order Release	0.00							
130									
QC	Memo	0.00							
Quality Control									

DAS
66
9-89

APR 22 2015

MCS 15-04-23

15-4-22

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
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☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge

☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

Picklist Print

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Page 1

Work Order ID: 127429

127429

Parent Item: D407-802-015

D407-802-015

Parent Item Name: High Vis Crew Door Opener Retrofit LH or RH

Start Date: 12/09/14

Required Date: 12/17/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 10.12.02 per revA DD verf:EC
12.07.30 AS PER ECN12-624 DD verf:EC

IPP Rev:D

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3552-17 *D3552-17* Door Prop	DAS 46 9-89	Manufactured	No			105	Each	1.0000	1	**			DAS 26 27 9-89
Location Loc Qty Loc Code													
ST364 1													
103639 1													
D3622-7 *D3622-7* Ball Stud	DAS 46 9-89	Manufactured	No			105	Each	19.0000	1	**			DAS 26 27 9-89
Location Loc Qty Loc Code													
ST052 19													
64339 6													
66168 13													
D3622-9 *D3622-9* Ball Stud	DAS 46 9-89	Manufactured	No			105	Each	17.0000	1	**			DAS 26 27 9-89
Location Loc Qty Loc Code													
ST052 17													
64207 3													
64340 14													
D4107-1 *D4107-1* Door Doublor	DAS 46 9-89	Manufactured	No			105	Each	3.0000	1	**			DAS 26 27 9-89
Location Loc Qty Loc Code													
ST090 3													
64397 3													

① 3126847

1X

1X

1X

APR 16 2015

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

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Work Order ID: 127429

127429

Parent Item: D407-802-015

D407-802-015

Parent Item Name: High Vis Crew Door Opener Retrofit LH or RH

Start Date: 12/09/14

Required Date: 12/17/14

Start Qty: 1.00

Required Qty: 1.00

D4107-5

DAS

Manufactured No

105

Each

10.0000

2

2

D4107-5

Spacer

Location

Loc Qty

Loc Code

ST090

10

64398

10

D4107-7

DAS

Manufactured No

105

Each

8.0000

1

1

D4107-7

Ball Stud Spacer

Location

Loc Qty

Loc Code

ST090

8

64399

8

D4111-3

DAS

Manufactured No

105

Each

3.0000

1

1

D4111-3

Sill Fitting

Location

Loc Qty

Loc Code

ST091

3

64345

3

CR3523-4-02

DAS

Purchased No

105

Each

367.0000

12

12

CR3523-4-02

RIVET

Location

Loc Qty

Loc Code

GA

300

m130415

300

ST318

67

m130415

67

CR3523-4-03

Purchased

No

105

Each

0.0000

10

CR3523-4-03

RIVET

10

m124876

APR 16 2015

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Shop Packet Print

Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design ☐									
Doc/Data ☐									
Equip/Tooling ☐									
Handling/Pre ☐									
Material ☐									
Operator ☐									
Offset/Setup ☐									
Process ☐									
Supplier ☐									
Training ☐									
Transport ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge	☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

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Work Order ID: 127429

127429

Parent Item: D407-802-015

D407-802-015

Parent Item Name: High Vis Crew Door Opener Retrofit LH or RH

Start Date: 12/09/14

Required Date: 12/17/14

Start Qty: 1.00

Required Qty: 1.00

CR3523-4-6

DAS Purchased

No

105

Each

76.0000

2

2

CR3523-4-6

Rivet

43
9-80

**

DAS 26 27
9-89 9-89

Location

Loc Qty

Loc Code

ST318

76

120422

76

105

Each

2,806.000

2

2

MS20426AD4-5

Purchased

No

MS20426AD4-5

RIVET

DAS
53
9-80

**

DAS 26 27
9-89 9-89

Location

Loc Qty

Loc Code

GA

110

m125807

110

ST312

2696

m125807

311

m130922

2385

105

Each

12.0000

1

MS21073L5

DAS Purchased

No

MS21073L5

Anchor Nut

53

**

① m131187

DAS 26 27
9-89 9-89

Location

Loc Qty

Loc Code

ST300

12

m130799

12

105

Each

49.0000

1

1

MS27039C5-11

Purchased

No

MS27039C5-11

Screw

DAS
43
9-80

**

DAS 26 27
9-89 9-89

Location

Loc Qty

Loc Code

ST282

49

123356

49

12

APR 16 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Doc/Data ☐									
Equip/Tooling ☐									
Handling/Pre ☐									
Material ☐									
Operator ☐									
Offset/Setup ☐									
Process ☐									
Supplier ☐									
Training ☐									
Transport ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
		☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

Picklist Print

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Work Order ID: 127429

127429

Parent Item: D407-802-015

D407-802-015

Parent Item Name: High Vis Crew Door Opener Retrofit LH or RH

Start Date: 12/09/14

Required Date: 12/17/14

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0563R

Purchased

No

105

Each

446.0000

4

4

NAS1149C0563R

Washer

DAS
28
9-89

APR 16 2015

Location

Loc Qty

Loc Code

ST271

446

m125928

46

m131026

400

44

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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REFERENCE ONLY

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5.2 D407-802-013/-014/-015 High Vis Crew Door Opener Kits

Qty -013	Qty -014	Qty -015	Part Number	Description
			D407-802-013	HIGH VIS CREW DOOR OPENER KIT, LH
			D407-802-014	HIGH VIS CREW DOOR OPENER KIT, RH
			D407-802-015	HIGH VIS CREW DOOR OPENER RETROFIT KIT
1	1	1	D3552-17	DOOR PROP
1	1	1	D3622-7	BALL STUD
1	1	1	D3622-9	BALL STUD
1			D4106-1	SILL DOUBLER, LH
	1		D4106-2	SILL DOUBLER, RH
1	1		D4106-5	SPACER, SILL DOUBLER
1	1		D4106-7	TEMPLATE
1	1	1	D4107-1	DOOR DOUBLER
2	2	2	D4107-5	SPACER
1	1	1	D4107-7	BALL STUD SPACER
1	1	1	D4111-3	SILL FITTING
12	12	12	CR3522-4-2	RIVET. ALT:M7885/5-4-2
10	10	10	CR3523-4-3	RIVET. ALT:M7885/4-4-3
4	4		CR3523-4-4	RIVET. ALT:M7885/4-4-4
2	2		CR3523-4-5	RIVET. ALT:M7885/4-4-5
10	10	2	CR3523-4-6	RIVET. ALT:M7885/4-4-6
6	6		CR3523-4-7	RIVET. ALT:M7885/4-4-7
4	4	2	MS20426AD4-5	RIVET
2	2	1	MS21073L5	ANCHOR NUT
1	1	1	MS27039C5-11	SCREW
4	4	4	NAS1149C0563R	WASHER

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